Work Order ID 99708

99708

April-11-13 2:54:03 PM

Item ID: D2974 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Packer

Start Date: 4/15/13 **Start Qty:** 12.00 *12* **Cust Item ID:**

Required Date: 4/16/13 **Req'd Qty:** 12.00 *12* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ML5 **Date:** 13-04-15 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2974	B								
100	FLOW WATER JET	0.00							
100									Ac 13.08.02
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2974								
304 040	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									Ac 13.08.02
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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Work Order ID 99708

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Item ID: D2974 **Accept** *N900040100* **Setup Start** *NS1*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						(20)		13-08-06	PD
QC	**Memo**	0.00							
Quality Control									
130		0.00							SP 13/09/20
130	NC BRAKE					20			
Brake NC	**Memo**	0.00							
Brake NC	Deburr and form on brake using DT8178 and DT8261as per Dwg D2974								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89
140						20			
QC	**Memo**	0.00							13926
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

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Item ID: D2974 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Packer

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Required Date: 4/16/13 **Req'd Qty:** 12.00 *12* **Customer:**
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Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						20	ø	ø	AJ 13-9-28
HandFinish	**Memo**	0.00							
Hand Finishing	Coat entire top concave surface with a layer or rockguard as per dwg A/R Rockguard batch: 126667								
160	QC3- Inspect Part Finish	0.00							
160						20			
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 55 020	0.00							
170						20 X			DAS 26 9-89
Packaging	**Memo**	0.00							
Packaging									

DAS 27 9-89 13-9-30

13-9-30

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

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- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

KJ / RM 13/09/30
MF
13-9-30

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
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- ☐ Other _____

Picklist Print

April-11-13 2:54:03 PM

Work Order ID: 99708

Parent Item: D2974 **Start Date:** 4/15/13 **Required Date:** 4/16/13

Parent Item Name: Packer **Start Qty:** 12.00 **Required Qty:** 12.00

Comments: IPP A00.05.30New IssueEC
IPP A06.11.20New IssueEC IPP REV:C 13.04.08 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	367.6500	**0.025**	**0.3157896**			

125754 → Ae 13.08.02

Location	Loc Qty	Loc Code	
MAT020	367.65		_____
124029	117.15		_____
124956	250.5		_____

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
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FAULT CATEGORY

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- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	99708
Description: Packer	Part Number:	D2974
Inspection Dwg: D2974 Rev: B		Page 1 of 1

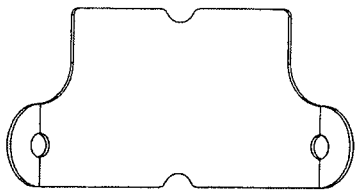
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

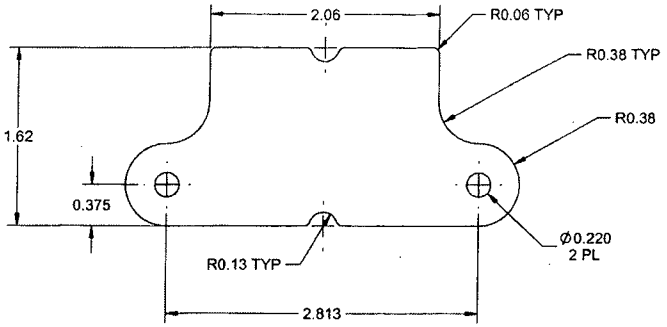
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.220	+0.005/-0.001	.224	-		V	JKm-01
0.375	+/-0.010	.375	-		V	
1.62	+/-0.030	1.60	-		V	
2.06	+/-0.030	2.06	-		V	
2.813	+/-0.010	2.813	-		V	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	13.08.02	Date:	13-08-06	Date:	N/A

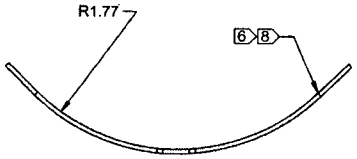
Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	



D2974 PACKER
MAKE FROM D2974F



D2974F FLAT PATTERN



RELEASED
2013-04-08

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
20 GAUGE (0.040 THICK), REF. DART SPEC. M304S20GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH P/N D2974 AND B/N AS PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
7) WEIGHT:0.05 lbs
8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK

99708 MC
13-04-15

REV.	DESCRIPTION	BY	DATE
B	FORMAT TO CURRENT STANDARD, AISI 304SS WAS 5052H-32 OR 6061-T6, REMOVE FINISH NOTE, ADD NOTE 8, ROCKGUARD COATING (ZN A8-1), REF CIR 12-13	DB	12.12.14
A	NEW RELEASE	RF	00.03.15

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	MB	DRAWING NO. D2974	REV. B
MFG. APPR.	DD		SHEET 1 OF 1
APPROVED		TITLE PACKER	SCALE NTS
DE APPR.			
DATE	12.12.14		

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